

Date: Thursday, 3/30/2006 10:05:50 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STRUT
Job Number	: 26446		
Estimate Number	: 10277		
P.O. Number	: N/A	Part Number	: D2565105
This Issue	: 3/30/2006 S.O. No. : N/A	Drawing Number	: D2565 REV E
Prsh Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: E
Previous Run	: 25973	Material	: N/A
Written By	: See comment below	Due Date	: 4/10/2006 Qty: 20 Um: Each
Checked & Approved By	: KJ 06.03.30		
Comment	: Est: F02.04.16 Added dwg Rev.C1 NG		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TR0750W049	304 RD Tube .750 x .049W	
		Comment: Qty.: 1.7666 f(s)/Unit Total : 35.3325 f(s) 304 RD TUBE .750 X.49W Punch 304/316/318-2B Seamless Tubing, 3/4" O.D. x 0.049" wall to length as per Dwg D2565 using DT 8313 Batch 17100540 M100 599 → FF 06.04.06 (M304TR0750W049)	FF 06.04.06
2.0	BRAKE NC	NC BRAKE	
		Comment: NC BRAKE Punch as per Dwg D2565 using DT 8313	FF 06.04.03
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Drill hole open to .316 Ø as per Dwg D2565 (one end only) Deburr	FF 06.04.11
4.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	JAC 04.12
5.0	POWDER COATING	POWDER COATING	
		Comment: POWDER COATING • Powder Coat White (Ref: 4.3.5.2) as per QSI 005 4.3	DC 06/05/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 26/05/02  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: STRUT

Job Number: 26446

Part Number: D2565105

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

*P06/5/01 (20)*

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST185

*B4/5/01 (20)*

8.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*DP 06/05/02 (20)*

Job Completion



*U 06/05/02*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

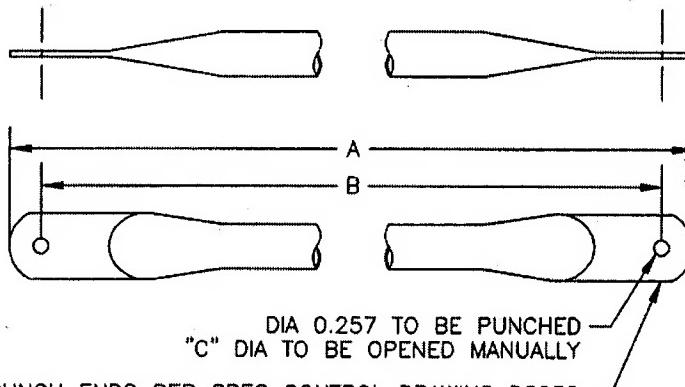
NOTE: Date & initial all entries

**DART**

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED	APPROVED	DRAWING NO.	REV. E	
		D2565	SHEET 1 OF 1	
DATE		TITLE	SCALE	
04.05.05		STRUT	1:3	
A	96.05.03	NEW ISSUE		
B	97.03.15	CORRECT D2565-111 DIM. A		
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)		
D	02.06.05	ADD -3XX PARTS; ADD FINISH		
E	04.05.05	ADD D2565-401-411; RMV ANGLE D		

**RELEASED**

04.05.05



PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	—
D2565-109	12.31	11.51	—
D2565-111	13.65	12.85	—
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	—
D2565-209	15.16	14.36	—
D2565-211	14.14	13.34	—
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	—
D2565-309	20.17	19.37	—
D2565-311	16.30	15.50	—
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	—
D2565-409	9.34	8.54	—
D2565-411	13.81	13.01	—

GENERAL NOTES

1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)

ENSURE SEAMLESS TUBE IS USED

2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3

3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES

SHOP COPY

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ENGINEERING

UNCONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 26446

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